

Date: Thursday, 2/23/2006 10:24:37 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 25933		
Estimate Number	: 11375		
P.O. Number	: N/A	Part Number	: D33871
This Issue	: 2/23/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/22/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>KJ 06.02.23</u>		
Comment	: Est:A 05.06.18 New Issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total : 12.5479 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6/T651 (QQ-A-200/8)  
 (M6061T6B0.500x06.000)  
 Identify for D3387-1  
 Batch: M1000 46

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank: 6.000" x 0.500" x 17.800" long

SAD 06/03/05

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA511 and Dwg D3387  
 Identify as D3387-1  
 C'sink Ø0.375" as per Dwg D3387  
 Tumble and Deburr NO sharp edges

ml 06/03/09

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/09

8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 22/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/23/2006 10:24:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25933

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/03/10 8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Patrick

R 06/3/14 8

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10 06/03/15 8

Job Completion



U 06.03.14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25933
<b>Description: Arm</b>		<b>Part Number:</b>	D3387-1
<b>Inspection Dwg: D3387 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R 0.125	✓			
0.125	+0.020/-0.000	0.127	✓			
Ø0.375 x100°	+/-0.010	Ø0.373x100°	✓			
R0.032	+/-0.010	R0.032	✓			
0.500	+/-0.010	0.495	✓			
0.500	+/-0.010	0.501	✓			
7.577	+/-0.010	7.580	✓			
R0.125	+/-0.010	R0.125	✓			
Ø0.507	+0.000/-0.001	Ø0.5067	✓			
0.250	+/-0.010	0.252	✓			
1.347	+/-0.010	1.344	✓			
2.000	+/-0.010	2.001	✓			
1.000	+/-0.010	0.999	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
R0.300	+/-0.010	R0.300	✓			
2.033	+/-0.010	2.032	✓			
<del>0.280</del> 0.300	+/-0.010	0.297	✓			
<del>0.222</del> 0.188	+/-0.010	0.188	✓			
1.700	+/-0.010	1.701	✓			

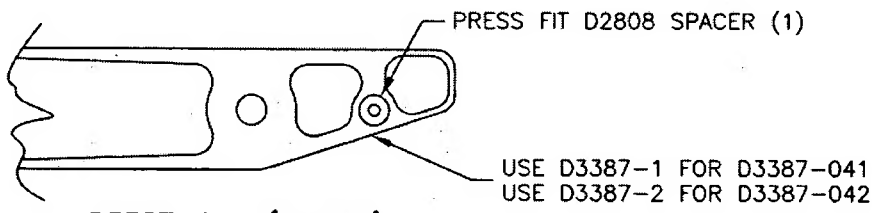
<b>Measured by:</b>	<i>JLM</i>	<b>Audited by:</b>	<i>En</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/03/09	<b>Date:</b>	06/03/09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	



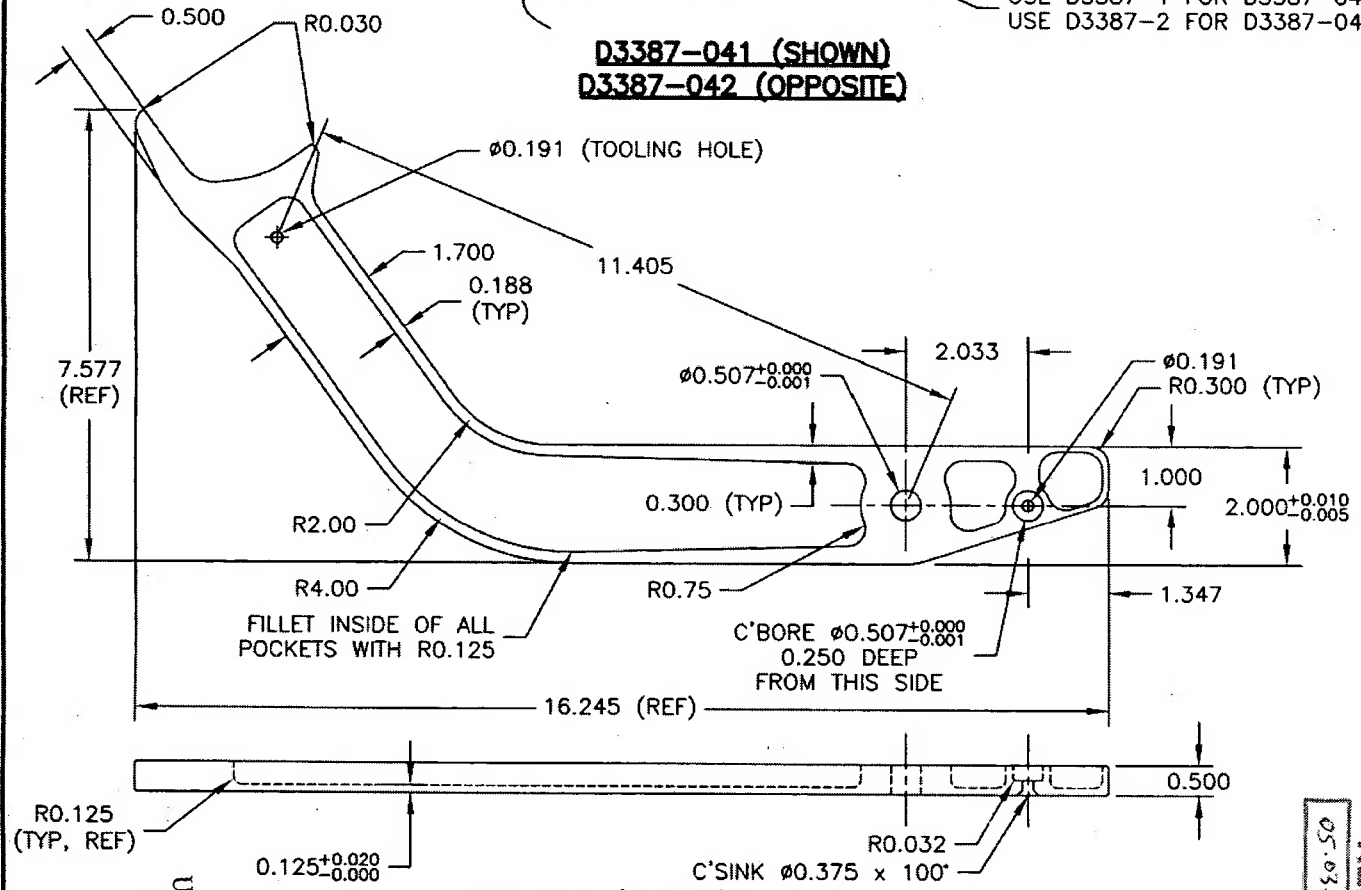
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	SCALE 1:3
	NEW ISSUE	

RELEASED  
05.03.11



**D3387-041 (SHOWN)**  
**D3387-042 (OPPOSITE)**

**D3387-1 (SHOWN)**  
**D3387-2 (OPPOSITE)**



**GENERAL NOTES**

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
  - 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
  - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
- UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25933

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